

Work Order ID 79056

79056

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January-19-12 9:29:46 AM

Item ID: D2945

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Mounting Plate

Start Date: 19/01/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: M.L.J.

Date: 12/01/19

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2945

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2945 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

6061 .188

12-2-19

(15)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-2-19

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

12-02-21 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79056

January-19-12 9:29:46 AM

N900040100

Setup Start *NS1*

Stop *NS2*

12

12

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130 Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Hand Finishing

Memo

0.00

14m / (2P) Feb. 22/2012

140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00
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0.00

140

Powdercoat

Powder Coating

Memo

POWDER COAT:

Start Time:

Oven Temperature:

Finish Time:

0.00

14x8 m - 12/02/20

150	QC3- Inspect Part Finish	0.00
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0.00

150

QC

Quality Control

Memo

0.00

14x of 3000/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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January-19-12 9:29:46 AM

Item ID: D2945 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Mounting Plate
 Start Date: 19/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 02/02/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>22</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MLJ 12/03/01
 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

January-19-12 9:29:50 AM

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Work Order ID: 79056

79056

Parent Item: D2945

D2945

Parent Item Name: Step Mounting Plate

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP B00.01.27Added inspect level 8, removed P/O for powder coatingEC
IPP Rev:C Now on Waterjet 06-12-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.188		Purchased		No		100	sf	27.0000	0.08	1.010526			

M6061T6S 188

6061-T6 .188 Sheet

**

B12-2-19

Location

Loc Qty

Loc Code

MAT021

27

116604

27

116604

(13)

W/O:		WORK ORDER CHANGES					
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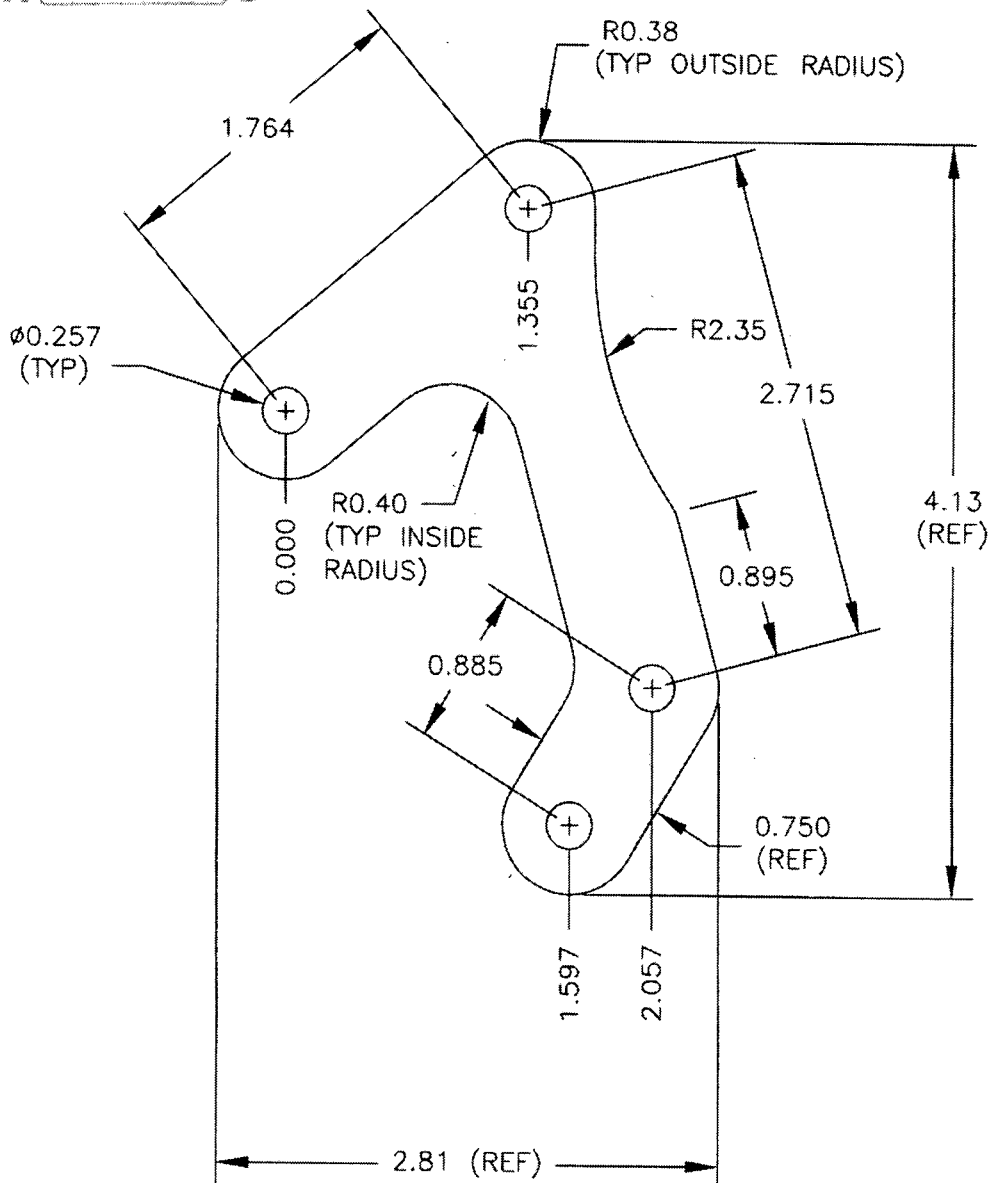
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2945	REV. A SHEET 1 OF 1
DATE 99.12.13		TITLE STEP MOUNTING PLATE	SCALE 1:1
A	99.12.13	NEW ISSUE	

RELEASED
99.12.21 DS



SHOWN
BY
UNCON. TO
SUBJECT TO
W/...
W/...
NO. 79.056
12/01/19

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
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